

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-49** Date Opened: **21 March 2017** Title: **Fabrication**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350/355** Product Type: **Cargo Basket Lid** Product Model: **Medium** Quantity: **5****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

DB
N/A
DB
DB
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69812	4	Lid Assembly	DB
84263	0	Lid Handle Brackets	DB
70405	4	Lid Walkway	DB

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2+2+1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking Tags (White) Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
JC
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

JC
N/A
N/A

Traveller

Work performed by:

ICC / Dual Inspection performed by:

Work Order closed by:

Print: D. BartfaiPrint: J. Clarke

Print: _____

Approved Manufacturing Facility 73-04

J. Francis / J. Reke
J. Clarke
C. Brander / J. Clarke

Sign: _____

Sign: _____

Sign: _____

Form 20.D.03

[Signature]
[Signature]
[Signature]

SCA: AD07SCA: AD02

SCA: _____

AD 01AD 02AD 02Date: 30-Mar-17Date: 30-Mar-17

Date: _____

Rev. Original 23 Sep 2014

Date: 14 Nov 17Date: 20 Nov 17Date: 24 Nov 17

#1 + #5
#2 + #3

#11
23 Nov 17



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Med. lid assy. No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69812-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-49-03

Remaining Tasks to be Performed: Prep for powder,
powder coat

Signature: David Marty

Date: April 7/2017 Lic. No. / SCA AD-05

In Process



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AMF 73-04

In Process

Remarks

Powder coat complete PO 17039 AD02



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AMF 73-04

Nomenclature: Med Lid assy. No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69812-05 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-49-05

Remaining Tasks to be Performed: Prep for powder coat,
powder coat.

Signature: David Marty

Date: March 24/2017 Lic. No. / SCA AD-05

In Process



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AMF 73-04

In Process

Remarks

INSPECTED 30 MAR 2017 JK.



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AMF 73-04

Nomenclature: Med. lid assy. No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69812-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-49-02

Remaining Tasks to be Performed: Prep for powder,

powder coat. ✓

Signature: David Duntz

Date: April 7/2017 Lic. No. / SCA AD-05

In Process



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AMF 73-04

In Process

Remarks

Powder Coat Complete PO 17039 4002



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AMF 73-04

Nomenclature: Med. Lid assy. No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69812-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-49-01

Remaining Tasks to be Performed: Prep. for powder coat,
powder coat.

Signature: David Martin

Date: March 24/2017 Lic. No. / SCA AD-05

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

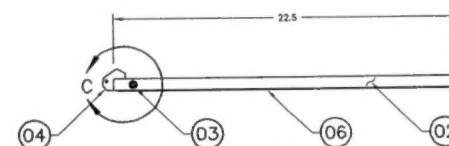
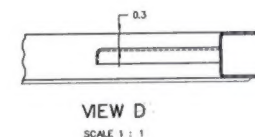
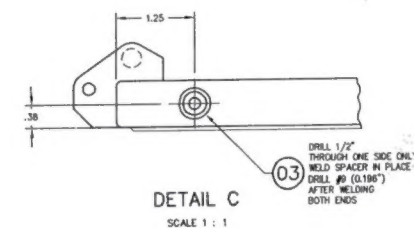
AMF 73-04

In Process

Remarks

INSPECTED 30 MAR 2017 - Ken OR

	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE		
1	CHANGED LOCATIONS OF SUPPORTS	RH	26 FEB 89
2	CHANGED HANDLE BRACKETS TO LEFT HAND CONFIGURATION	BUC	28 JAN 91
3	CHANGED LOCATION OF SUPPORTS, REMOVED SLOTTED CONFIGURATIONS	BUC	15 SEPT 91
4	TITLE BLOCK UPDATED; B42626 CHANGED TO B42635, WELDING ROD UPGRADES; # OF WELDS DOWN FROM 7, CEMENT MODIFIED, EXPLOSIVE DEVICES ADDED	BUC	11/07/2014
5	V/A HOLES FOR BUMPER ADDED, V/W ID ADDED		



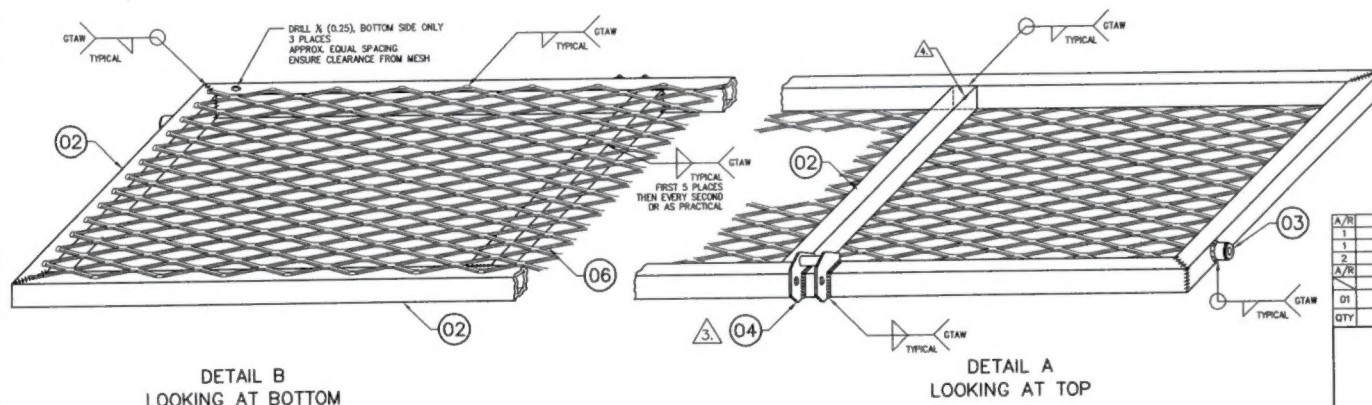
NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D8.05C.
3. 4130 AND 1018 STEEL: WELDING SHALL CONFORM TO EPOXY-2 OR EQUIVALENT.
4. STEEL 4130 AND 4130 STEEL: WELDING ROL SHALL CONFORM TO E309L OR EQUIVALENT.

INSTALL ITEM 4 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.

DRILL $\phi 0.1219$ HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO MATE WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED WELD HOLES WITH ROSETTE WELD.

FINISH, THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.



A/R	3/4-16F	06	MESH	MILD STEEL	COMMERCIAL		
	35034-10	05	TR ACARO BRACKET				
1	84263-01	04	LID HANDLE PROVISIONS ASSEMBLY				
2	42216-01	03	SPACER				
A/R	--	02	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.75 X 0.035 SQ. TUBE	
	68812-01	01	BASKET LID ASSEMBLY				
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						

APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURCOIN		DATE 11 APR 2006		AERO DESIGN LTD. 6080A MALAYSIA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 250.480.2878 www.aerodesign.ca
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1 ANGLES ±1/2°		QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY		
SCALE 1 : 4 SHEET 1 OF 1		DWG. SIZE A1	DWG. NO. 69812	REV. 4

2017-49
(5) of medium lid assys.
with walk ways.

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right) ← *

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2017-49

Date Open: 21 March 2017

DRM

Parts # 1 and 5 OK

1. Rim Assembly – Basket Lid

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

- Record welding rod PO on attached material list.

3. Inspection

- Rim for complete welds

4. Frame assembly – Lid

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Insert rim from step 2 into jig.
- Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

7. Inspection

- Frame assembly for complete welds.

CARGO BASKET LID FABRICATION

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 9.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lid prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

Work Order: 2017-49Date Opened: March 2017

Material Tracking Sheet
Bell 206L / 407 and Eurocopter AS350 / AS355
Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	POWO
	<u>5</u>		69812-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17004</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17004</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14033</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 3		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17004</u>
Step 5		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 8		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>16072/17038</u>
Step 6				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14033</u>
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 8				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 75" x 22")	3/4-16F Expanded Mild Steel sheet	<u>17025</u>
Step 9				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	<u>16078</u>

Work Order: 2017-49Material Tracking Sheet
Bell 206L / 407 and Eurocopter AS350 / AS355
Lid Fabrication

2 of 2

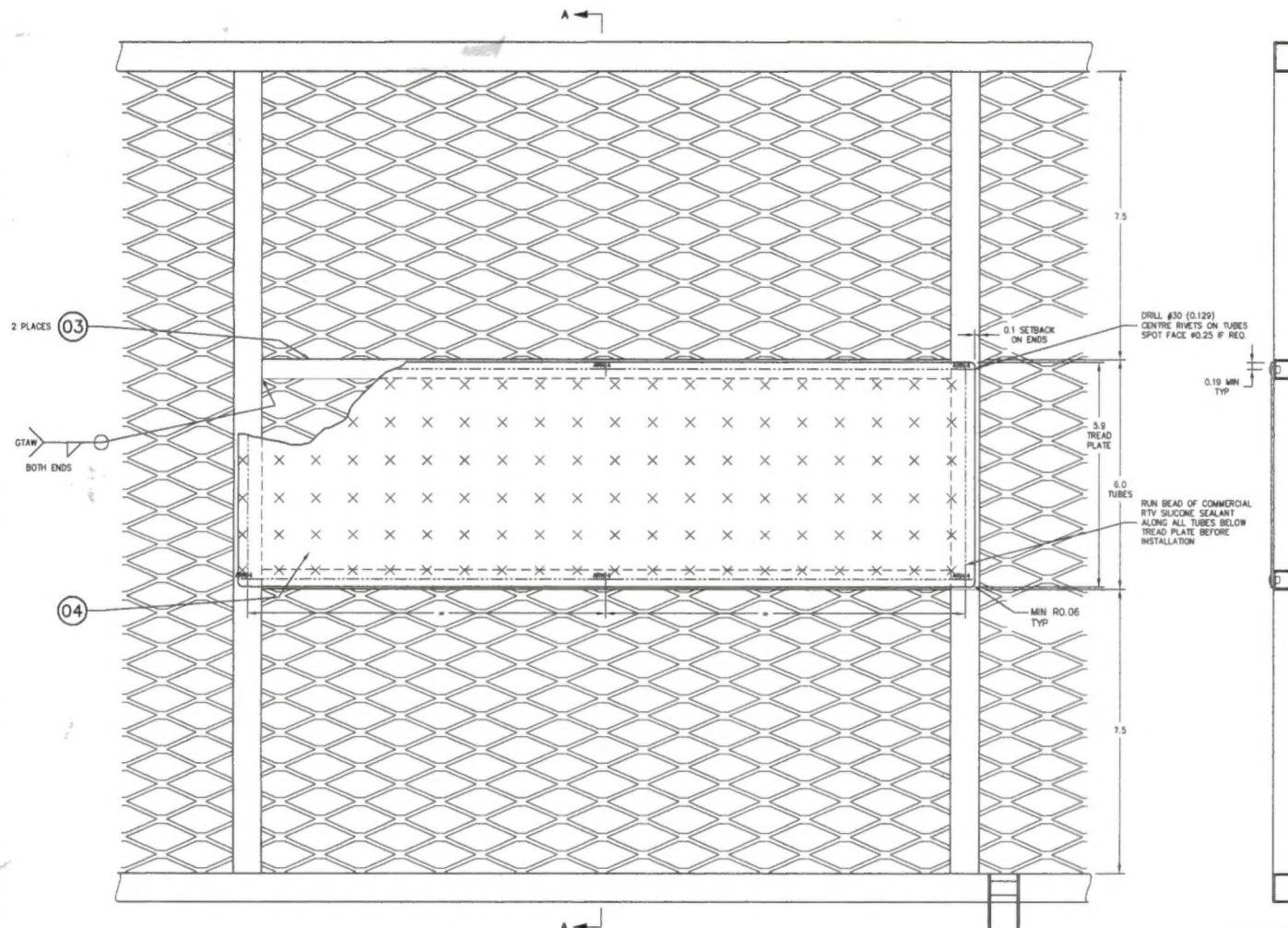
Date Opened: March 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
Step 10.a.	1	84262	84262-01	Upper Handle Bracket Assembly		2016-147
	4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	2		36275-02	Support	304 Stainless, 5/16" Rod	
	A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 10.b.	2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 10.c.	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2016-119
	A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>		17035 / 17039

(1+5) (2+3)

17105 (#4)

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BUC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD500N, BELL 206B BASKETS	BUC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BUC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BUC	28/05/2014



(01) BASKET LID ASSEMBLY

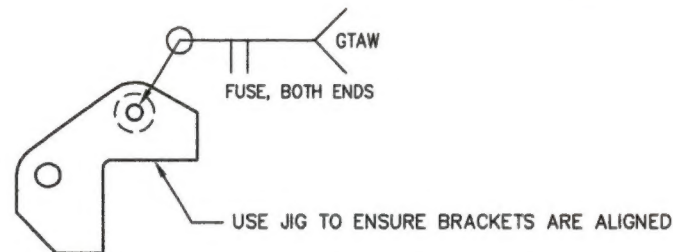
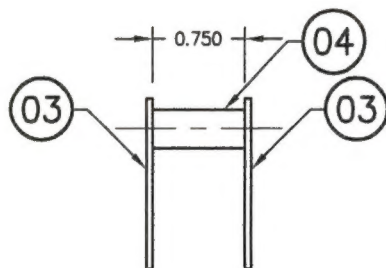
SECTION A-A

- NOTES:
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
 2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
 3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
 7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

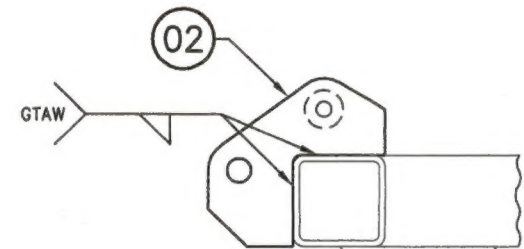
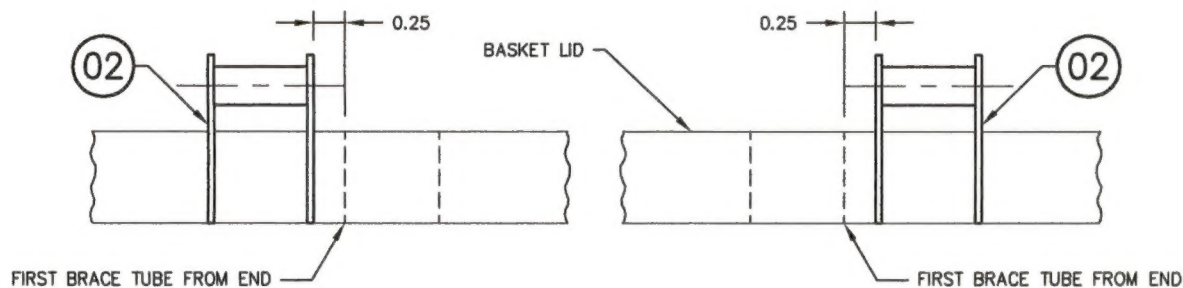
A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF: HAS 523 C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED BASIC CODES: BU=MS20470AD BB=MS20426AD ARN=CR3213 ARM=CR3212		DASH NO. FOR DIAMETER H=H/D, HEAD NEAR SIDE F=H/D, HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGOIN DATE: 21 SEPT 2008		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 8800A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 864.485.8976 www.aerodesign.ca	
CARGO BASKET LID STEP MODIFICATION				SCALE 1:1.5 SHEET 1 OF 1		DWG. NO. 70405 REV. 4			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 84262 REV. 1	BJC	14/02/2014



02 HANDLE BRACKET ASSEMBLY



01 LID HANDLE PROVISIONS ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275-02	04	SUPPORT
2		36273-01	03	LID BRACKET
	2	84263-02	02	HANDLE BRACKET ASSEMBLY
		84263-01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS		DATE
DRAWN:	JEFF CLARKE	14 FEB 2014
CHECKED:	JASON REKVE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		
DECIMALS	ANGLES	
X.XXX ±0.010	±1/2°	
X.XX ±0.03		
X.X ±0.1		

 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.489.8376 www.aerodesign.ca		HELICOPTER CARGO BASKET LID HANDLE PROVISIONS ASSEMBLY	
		SCALE 1 : 1	REV.
SHEET 1 OF 1	A3	84263	0